PATENT ABSTRACTS OF JAPAN

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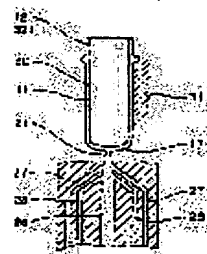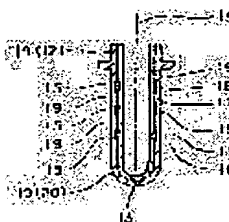(71)Applicant : TOYO SEIKAN KAISHA LTD

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(54) COLORED MULTILAYER VESSEL AND MANUFACTURE THEREOF

(57)Abstract:

PURPOSE: To enable constitution of a lateral-striped pattern in an axial direction of a vessel, by a method wherein a bottoned tubular preform whose wall is divided into a colored multilayer part and surface resin layer part is molded by injection molding, to begin with, to which blow molding is performed.

CONSTITUTION: A gate 21 is provided on a mold 31 position corresponding to the central part of the bottom 13 of a preform 11 to which resin is fed at a time or one after another through an inner surface resin passage 26, outer surface resin passage 27 and colored resin passage 28 so that the inner surface resin 16, outer surface resin 17 and the inner surface resin 16, outer surface resin 17 and colored resin 18 are positioned respectively at the central position, outside and between both the resin 16, 17 of the gate. At the time of molding of a surface resin layer part 19 and a colored multilayer part 15, resin is fed respectively through one side or both sides of the inner/outer surface resin passages 26, 27 and the inner/outer surface resin passages 26, 27 and colored resin passage 28 at the same time or one after another. Then the surface resin layer part 19 is formed into at least the upper end part 12 and the vicinity part 20 of the gate of the preform 11 and blow molding is performed to the preform formed so that the colored resin layer part 15 becomes alternate with the surface resin layer part 19 in an axial direction.

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